

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015001**Date Inspected:** 31-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG COMPONENT		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

**Magnetic Particle Testing (MPT)**

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Segment 10CW. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SEG063C-003,004,015,019,020,045,046

SSD10A-PP92-090

SSD22-PP92.5-079~084,089~094

SSD11A-PP93-280~283,182,183,034~039,026~031,082~088

SP778-005~010,017~020

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 10CW, this Quality Assurance (QA) Inspector discovered four(4) Linear indications on the following welds that Weld # SEG063C-045: One (1) Transverse linear indication measuring approximately 13 mm in length. Weld # OBW11-022: One (1) Transverse linear indication measuring approximately 15 mm in length. Weld # SEG063C-026: One (1) Transverse linear indication measuring approximately 13 mm in length. Weld #

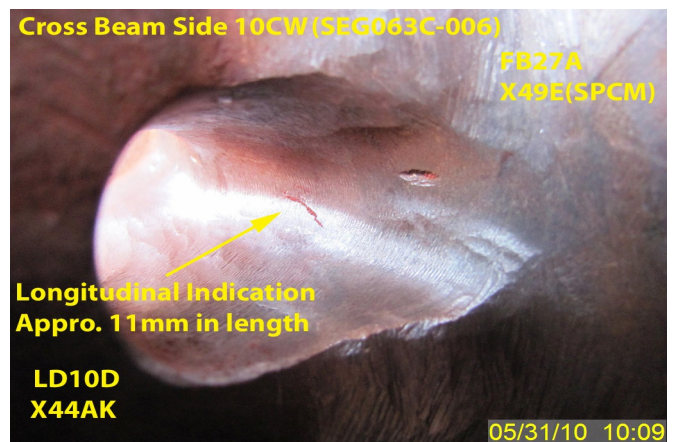
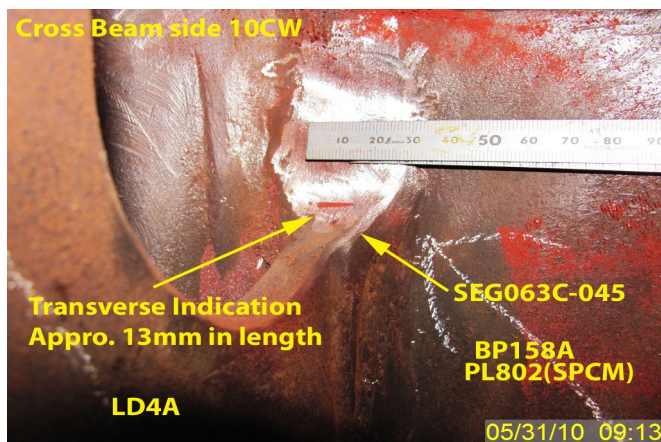
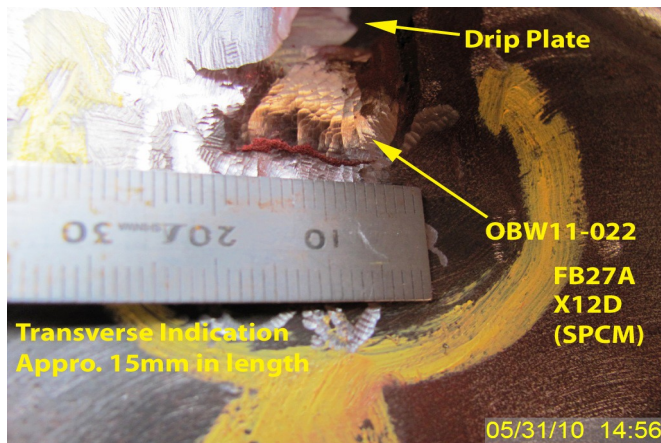
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SEG063C-006: One (1) longitudinal linear indication measuring approximately 11 mm in length. All indications are clearly marked on the material near the weld. All welds are designated as Seismic Performance Critical Material (SPCM). Weld SEG063C-045 is a Complete Joint Penetration (CJP) joint joining between LD4A (X68B) Non SPCM to BP158A (PL802A) SPCM at Cross Beam Side. Weld OBW11-022 is a fillet weld joint joining between Drip plate to Floor Beam FB27A(X12D) SPCM at Panel Point PP94 (Cross Beam Side). The weld SEG063C-026 is a CJP weld joint joining between FB27A (X49E) SPCM to LD10D (X70N) Non SPCM. The weld SEG063C-006 is a CJP weld joint joining between FB27A (X49E) SPCM to LD10D (X44AK) Non SPCM. OBG segment 10CW is located outside west of Bay#16. The Notice of Witness Inspection Number (NWIT) is 005839. The indications are located inside an area that has been previously tested by ZPMC Quality Control (QC) personnel.

The QA inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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